


Date: Wednesday, 21/01/2009 9:14:41 AM
 User: Linda Lacelle

Process Sheet

SPVT

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TIRE AND RIM ASSEMBLY
Job Number : 45006	
Estimate Number : 11156	
P.O. Number :	Part Number : D32339
This Issue : 21/01/2009 S.O. No. :	Drawing Number : D3233
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 43628	Material :
Written By : 	Due Date : 28/01/2009 Qty: 20 Um: Each
Checked & Approved By :	
Comment : Est A: 05.03.03 New issue: KJ/JLM	
Est B: 08.11.28 QC6 moved to step 4 KJ Verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 8012

C209101121

For D3233-9 Tire and Rim Assembly P/N: 8353T74

Possible Supplier: McMaster-Carr

Product Specification sheet is required

eto (20)

2.0	8353T74	TIRE & RIM
-----	---------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Tire & Rim Assembly

C 9/1/22 (5)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

Identify and Stock

Location: WA

C 9/01/22 5

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

Sordal23 (X5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD 09-02-20 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/01/2009 9:14:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TIRE AND RIM ASSEMBLY

Job Number: 45006

Part Number: D32339

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/23 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

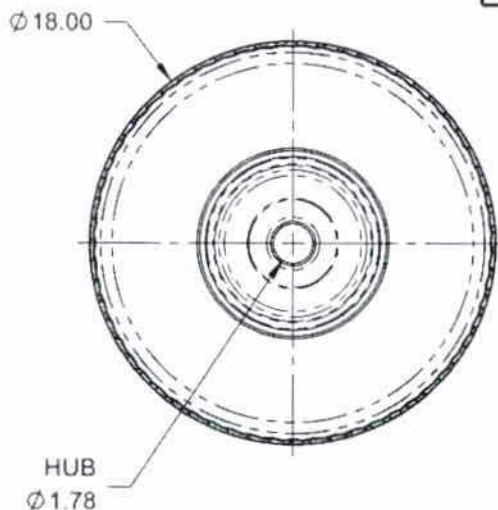
Job Completion



MF
09-02-20

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 7#	APPROVED [Signature]	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

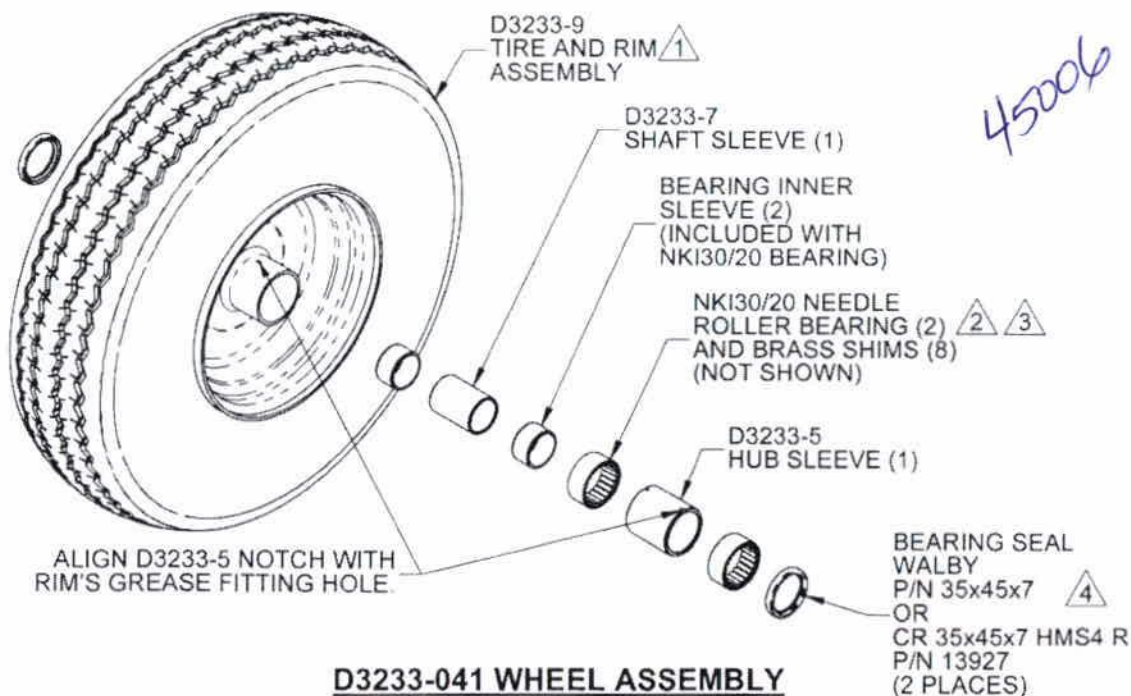


RELEASED
[Signature]
05/05/08

WHEEL SPECIFICATIONS

SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMENDATIONS
ARE 75 PSI FOR HIGH SPEED USE.

**NOTES:**

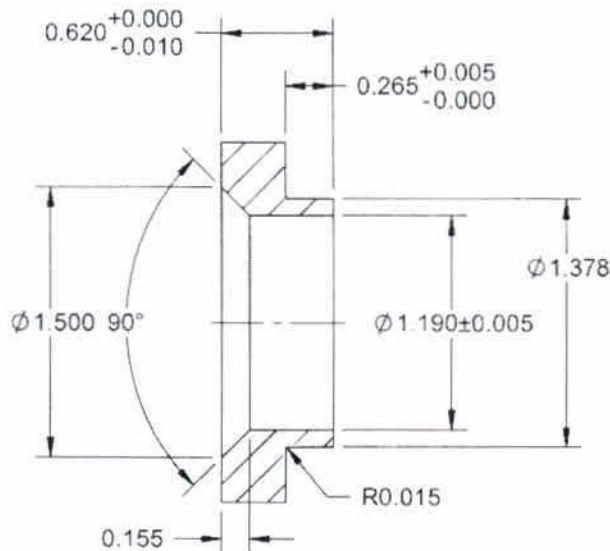
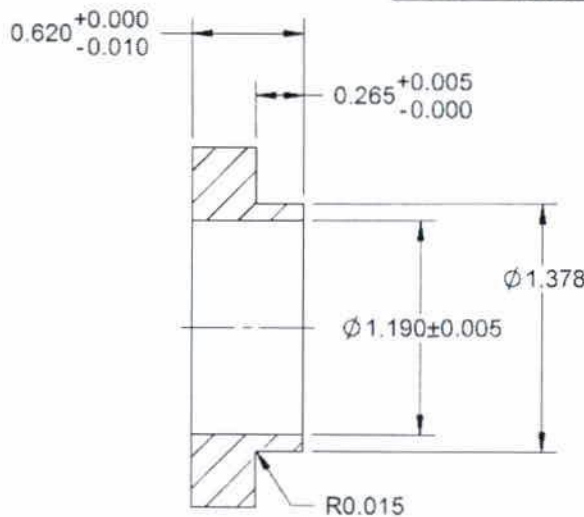
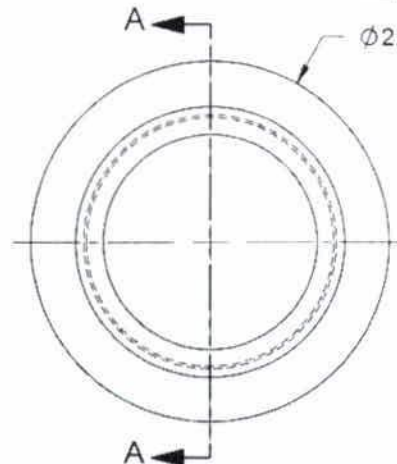
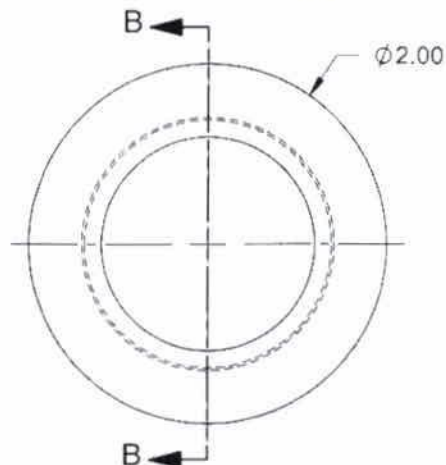
- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

**SECTION A-A****D3233-1 INSIDE WASHER****SECTION B-B****D3233-3 OUTSIDE WASHER****NOTES:**

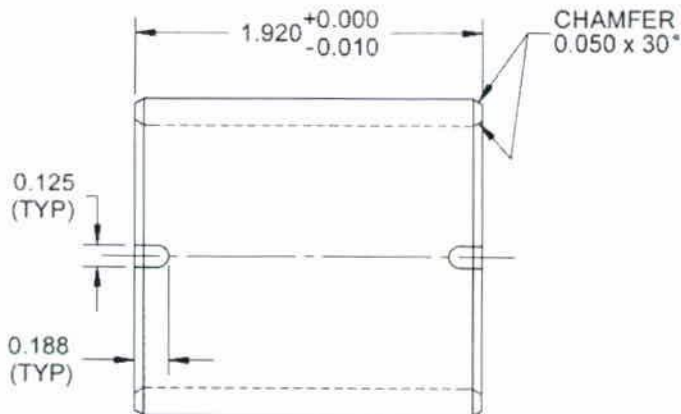
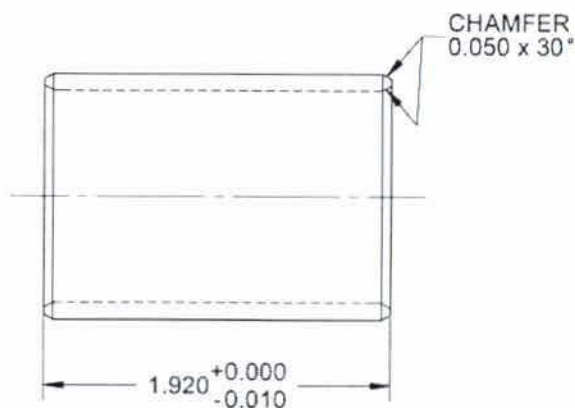
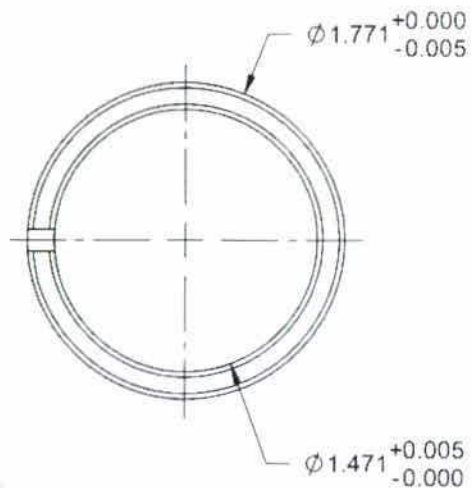
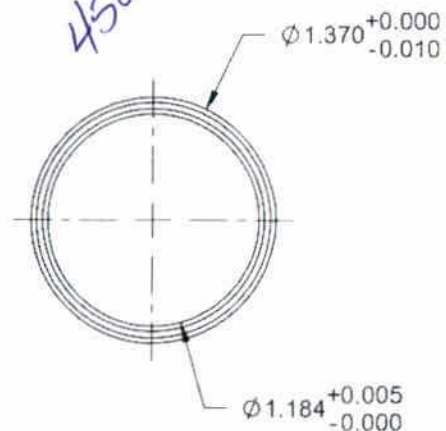
- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1

**D3233-5 HUB SLEEVE****D3233-7 SHAFT SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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Purchase Order
PO00008012

Page 1 of 2

200 Aurora Industrial Pkwy
Aurora, OH 44202-8087
330-955-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Main Finished Goods Location

McMaster-Carr Number
2510465-02

01/21/2009

Line	Description	Ordered	Shipped	
1	5606A170 Nylon 6/6 Small-OD Flat Washer, 7/16" Screw Size, 1/2" ID, 11/16" OD, .028"-.034" Thickness, Packs of 100	1 Pack	1	2 - 623 - 02 04 - 05 A170 1 PK
2	3695K88 Neoprene/Vinyl/Buna-N Foam Rubber Strip, Adhesive-Back, 1/4" Thick, 1" Width, 50' L, Black	1 Each	1	1 - 253
3	353T74 Pneumatic Wheel with One-Piece Rim, 18" X 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 1590#cap	20 Each	5	8 - 79
4	875K217 Nylon T-Strainer, Clear Bowl, 3/4" NPT Female, 40 X 36 Mesh Screen Your Part Number: REPLACES 9875K117 (DISCONTINUED)	1 Each	1	1 - 238
5	0261A164 Helical Insert Installation Tool, 3/8"-24 Internal Thread, Style A	1 Each	1	2 - 136

Shipped separately from our Chicago warehouse on 01/21

3	353T74 Pneumatic Wheel with One-Piece Rim, 18" X 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 1590#cap	20 Each	15
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Dart Aerospace Ltd

Assembly
Area

91

Cycle

22

Self

1:52

Documents

EXP

7E
51

FW1WE
01/21/2
09:36/11
711

55-0707

9002136027625

